

Date: Wednesday, 13/08/2008 10:54:46 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	02.250 SUPPORT
<b>Job Number</b> :	41198		
<b>Estimate Number</b> :	11057		
<b>P.O. Number</b> :		<b>Part Number</b> :	D28911
<b>This Issue</b> :	13/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2891 REV A1
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40336	<b>Drawing Revision</b> :	A1
	<b>Type</b> :	<b>Material</b> :	
	PURCHASED PARTS	<b>Due Date</b> :	20/08/2008
<b>Written By</b> :		<b>Qty:</b>	20
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	JLO 08.8.13		
<b>Comment</b> :	Est. C 02.11.26 Added P/O KJ		
	Est D 08.03.19 Re-format EC verified: DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DSK076	D2891-1 TURNING DETAIL
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**Comment:** Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2891-1 TURNING DETAIL

Batch: 41004

JLO 08.09.27

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS

Machine as per Folio FA046

Tumble &amp; Deburr

DIP 08/09/27

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(20)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/09/27

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

m-h 08/09/29

(20)

5.0	POWDER COATING	POWDER COATING
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M109152



(20x)

**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15  
 400 OF  
 3:45

m-h 08/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 13/08/2008 10:54:46 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 41198

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-28 (X) 30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml

08 09 30

(20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30 HJ

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 411198
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.190	0.190	0.190
AB	0.240	0.260		0.250	0.250	0.249	0.249	0.249
AC	0.115	0.150		0.125	0.125	0.1265	0.126	0.126
AD	0.040	0.060		0.049	0.049	0.050	0.050	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.139	0.139	0.140	0.140	0.140
AI	0.454	0.474		0.460	0.460	0.462	0.462	0.461
AJ	2.779	2.789		2.782	2.782	2.782	2.782	2.782
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.035	1.035	1.038	1.038	1.035
AM	0.053	0.073		0.060	0.060	0.055	0.055	0.060
AN	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AO	1.663	1.683		1.675	1.675	1.674	1.674	1.675
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: DTP	Date: 08/09/27
Audited by: MK	Date: 08/09/29
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	41198
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b>	D2891-1
<b>Inspection Dwg:</b> D2891	<b>Rev:</b> A1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.188	0.193		0.190	0.1895	0.1895	0.190	0.190
AB	0.240	0.260		0.249	0.249	0.249	0.249	0.249
AC	0.115	0.150		0.126	0.125	0.125	0.126	0.126
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.140	0.140	0.140	0.140	0.140
AI	0.454	0.474		0.461	0.462	0.461	0.463	0.463
AJ	2.779	2.789		2.782	2.783	2.782	2.782	2.782
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.035	1.037	1.037	1.033	1.040
AM	0.053	0.073		0.060	0.060	0.060	0.060	0.060
AN	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AO	1.663	1.683		1.6715	1.672	1.672	1.672	1.672
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> JTP	<b>Date:</b> 08/09/27
<b>Audited by:</b> MK	<b>Date:</b> 08/09/29
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41198
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b> D2891-1
<b>Inspection Dwg:</b> D2891	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.126	0.126	0.126	0.126	0.126
AD	0.040	0.060		0.049	0.049	0.050	0.050	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.138	0.139	0.139	0.140	0.139
AI	0.454	0.474		0.4615	0.463	0.463	0.461	0.4625
AJ	2.779	2.789		2.782	2.782	2.782	2.782	2.782
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.038	1.038	1.039	1.033	1.0365
AM	0.053	0.073		0.060	0.060	0.060	0.060	0.060
AN	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AO	1.663	1.683		1.671	1.672	1.675	1.673	1.675
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> DTP	<b>Date:</b> 08/09/28
<b>Audited by:</b> GML	<b>Date:</b> 08/09/29
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	41198
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.127	0.126	0.127	0.126	0.126
AD	0.040	0.060		0.050	0.050	0.050	0.049	0.049
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.139	0.139	0.139	0.140	0.140
AI	0.454	0.474		0.4625	0.462	0.4585	0.461	0.461
AJ	2.779	2.789		2.782	2.782	2.782	2.782	2.782
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.0365	1.038	1.035	1.037	1.038
AM	0.053	0.073		0.060	0.060	0.060	0.060	0.060
AN	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AO	1.663	1.683		1.675	1.673	1.673	1.674	1.674
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

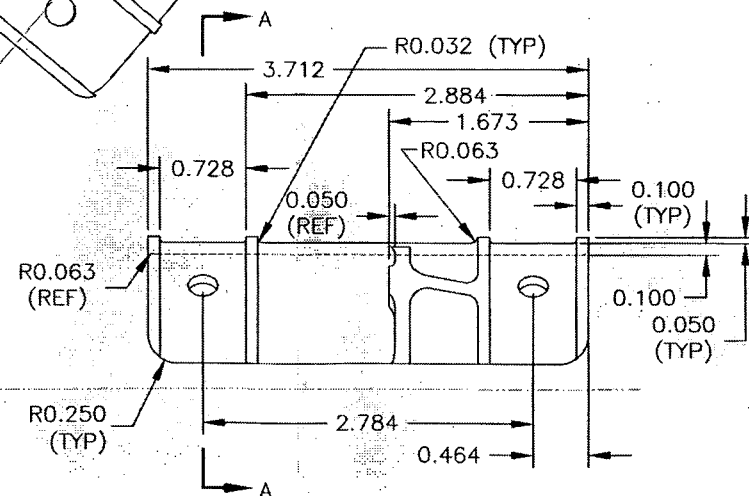
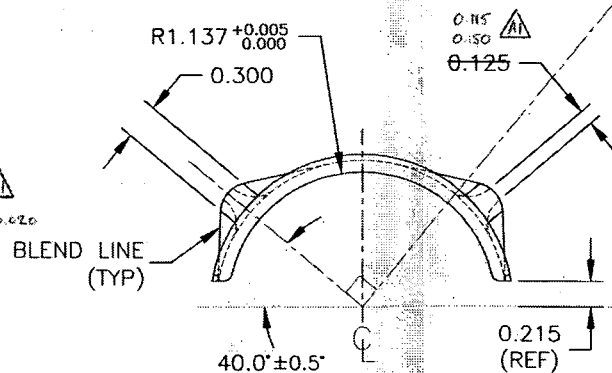
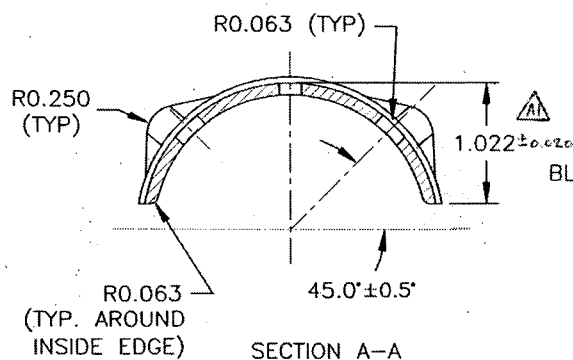
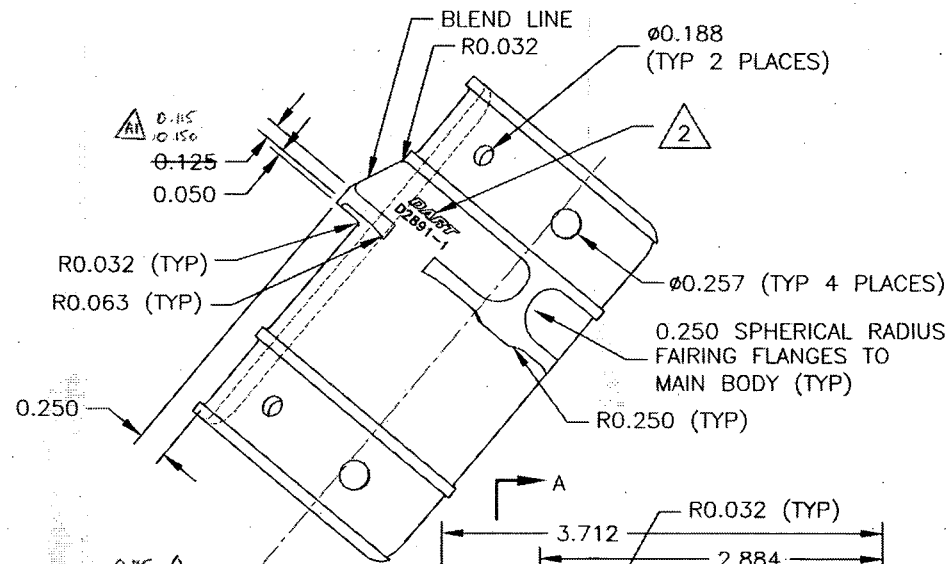
Measured by:	DJP	Date:	08/09/28
Audited by:	Am	Date:	08/09/29
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	



D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



NO. 41198  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

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AI	CP 02-01-23	UPDATE DIMS AS MANUFACTURED
A	00.11.17	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMMERSBURY, OXFORD, CANADA
CHECKED	APPROVED	DRAWING NO. D2891
DATE	00.11.17	TITLE: $\phi 2.250$ SUPPORT
		REV. A SHEET 1 OF 1 SCALE 1:1